

Work Order ID 53199

October 26, 2009 12:40:54 PM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09/10/26	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
	2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221								
	3- tack weld mesh on basket as per dwg D2221								
	A/R ER316 S.S. Rod Batch: M109213								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

Plc 09 10 30

ID 09.11.02

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Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	↓ pressure wash	0.00							
	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel								
Powdercoat	1112248	0.00							
Powder Coating	Memo								
	1- Plug holes prior to								

1ST COAT:
 START TIME: 2:00 pm
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 2:30 pm
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME: 2:30 pm
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 3:00 pm

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Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00

OK 09-11-14

D



QC

Memo

0.00

Quality Control

150

IDENTIFY & STOCK

PPR 52036 PC 9/11/05 (1)

~~150~~ 160

QC21- Final Inspection - Work Order Release

0.00

0.00



QC

Memo

Quality Control

09/11/05

Pl 09-11-5

Picklist Print

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Page 1

Work Order ID: 53199

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Comments:

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-1RevH

Manufactured

No

100

Each

13.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

12

51872 ✓

12

D2221-5RevH

Manufactured

No

100

Each

2.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

50026

2

D2221-7RevH

Manufactured

No

100

Each

5.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

5

51090

1

51251 ✓

4

Eplog 10.28

①

Eplog 10.28

B53131 → ② ✓

Eplog 10.28

①

Picklist Print

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Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3RevC

Manufactured

No

100

Each

13.0000

2.0000



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

50024

2

51870 ✓

11

100

Each

20.0000

2.0000

D2235-1RevB1

Manufactured

No



Basket Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

51438 ✓

7

Main Warehouse

WA

13

50565

3

51871

10

Cpl 09.10.28

② Cpl 09.10.28

②

Picklist Print

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2581RevA1

Manufactured

No

100

Each

66.0000

2.0000



Mounting Bracket

Pl 09.10.28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46086

2

48428

1

51120

10

Main Warehouse

WA

53

50872

4

51745 ✓

49

D3442-1RevA

Manufactured

No

100

Each

18.0000

2.0000



Shim

②

Pl 09.10.28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

46767

1

Main Warehouse

WA

17

50951 ✓

17

②

Picklist Print

October 26, 2009 12:40:59 PM

Work Order ID: 53199

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Reate Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	8.0000	2.0000			
												
Rib Assembly (Basket End)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

51869 ✓

6

Main Warehouse

WA

2

51171

2

D3826-041RevB

Manufactured

No



Rib / Gusset Assembly

100

Each

8.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

51340 ✓

6

Main Warehouse

WA

2

51088

2

Picklist Print

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Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	5.0000	1.0000			
Rib Assembly (Inboard)												

Pl 09.10.28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
51339 ✓	5	

D3832-1RevA

Manufactured No



Mesh (Base)

100	Each	6.0000	1.0000
-----	------	--------	--------

①

Pl 09.10.29

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
46306	1	
46774	1	
Main Warehouse		
WA	4	
50942 ✓	1	
51863	3	

①

Picklist Print

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Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3833-1RevA

Manufactured

No

100

Each

10.0000

2.0000



Mesh (Base End Face)



Pl 09-10-29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

51304 ✓

8

Main Warehouse

WA

2

50025

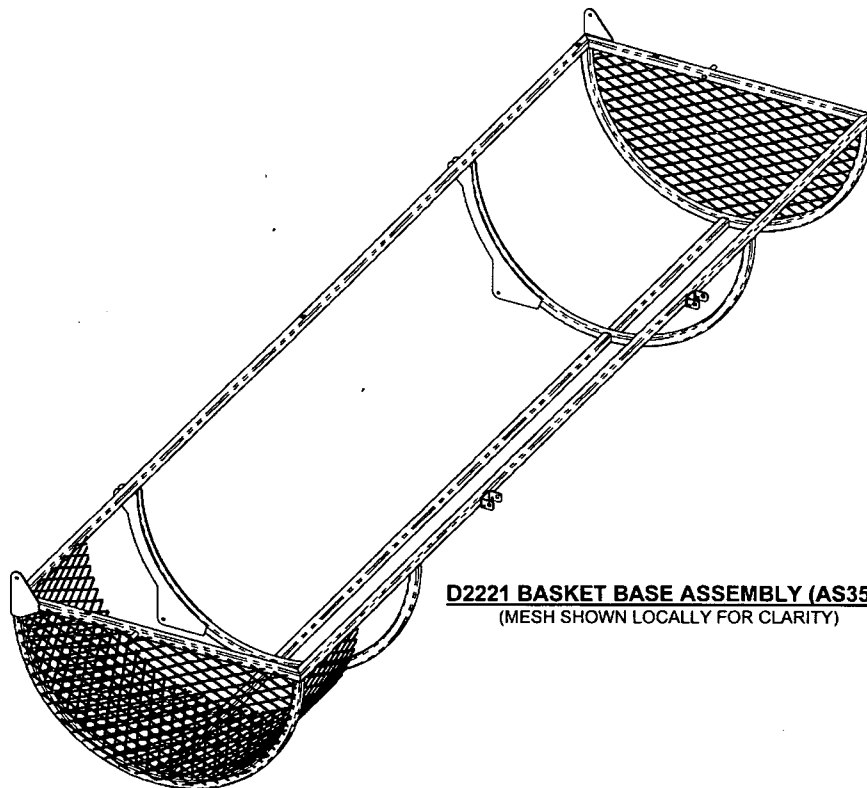
2

(2)

October 26, 2009 12:40:59 PM

Shop Packet Print

Page 6



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOR COPY
REVISION
ENGINEER
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 53199

18/09/16-24

NOTES:

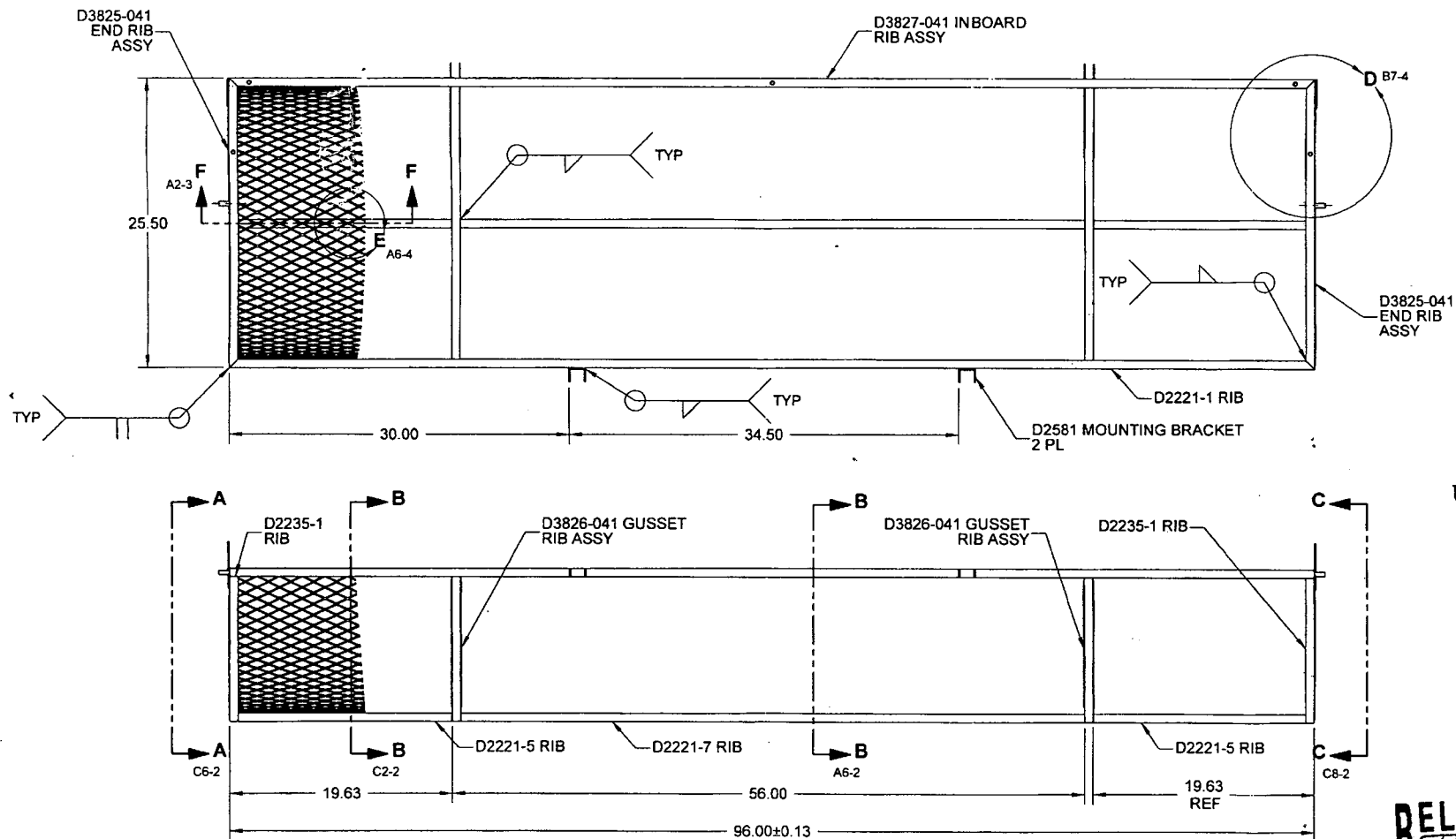
MATERIAL: N/A
FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 42.00 lbs APPROX
MASK ALL HOLES PRIOR TO POWDER COATING

H

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/16






H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2321-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

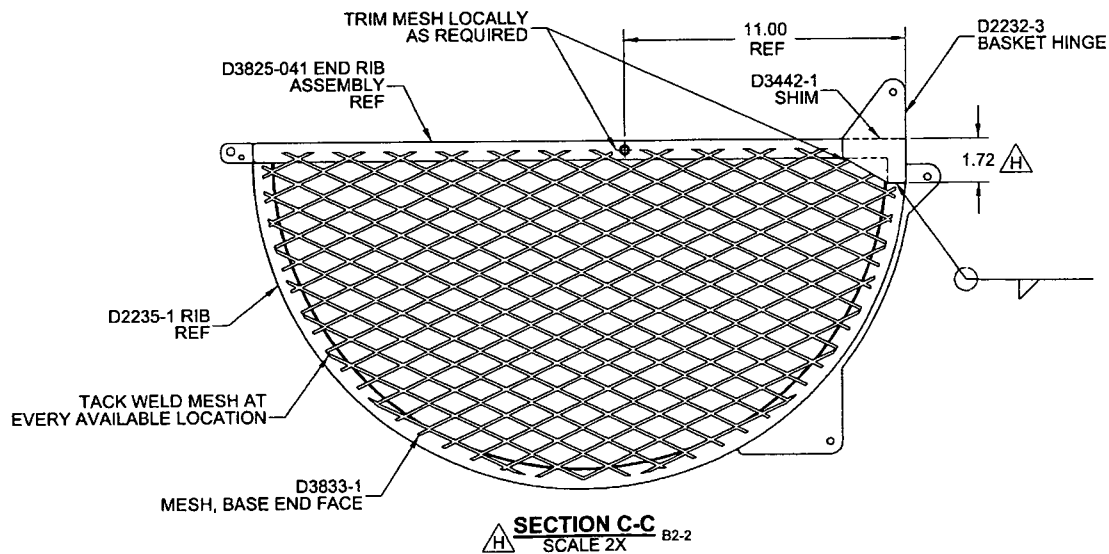
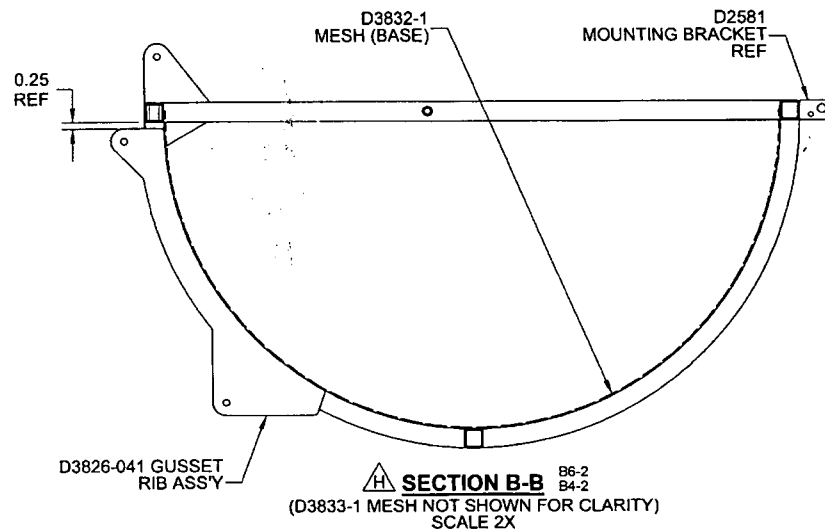
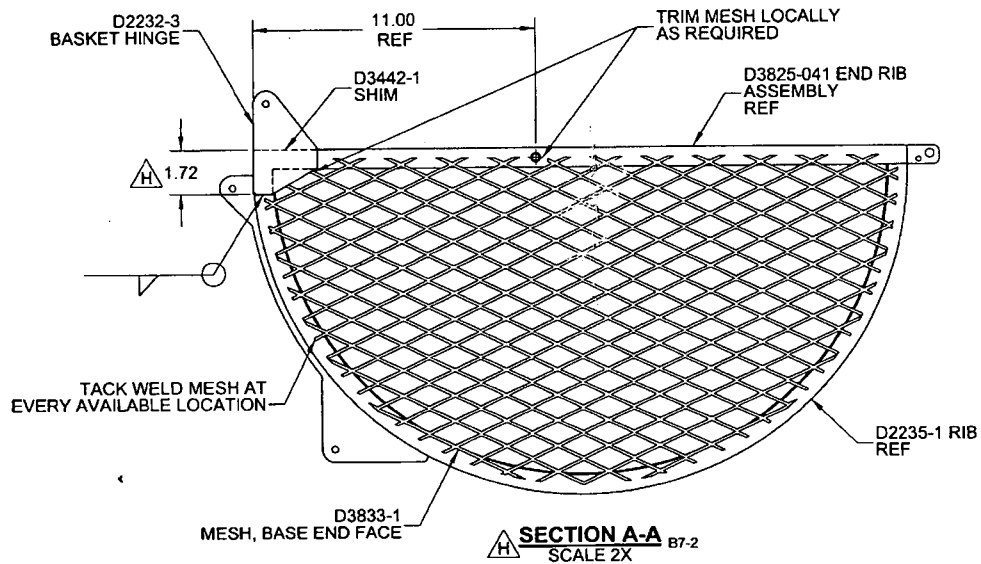


SHOP C
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO. 53199

RELEASED
06/11/18

D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

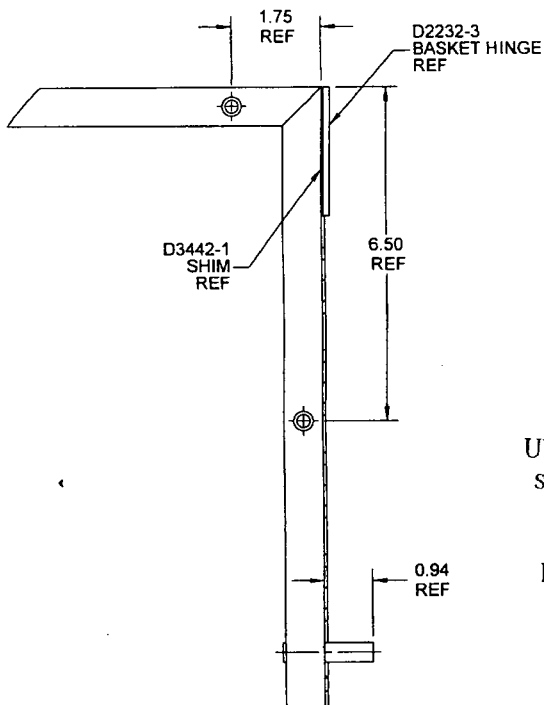
DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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WORK ORDER
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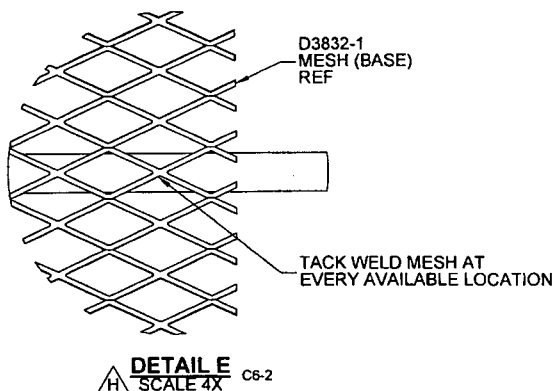
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03/11/18

DESIGN	EW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	235	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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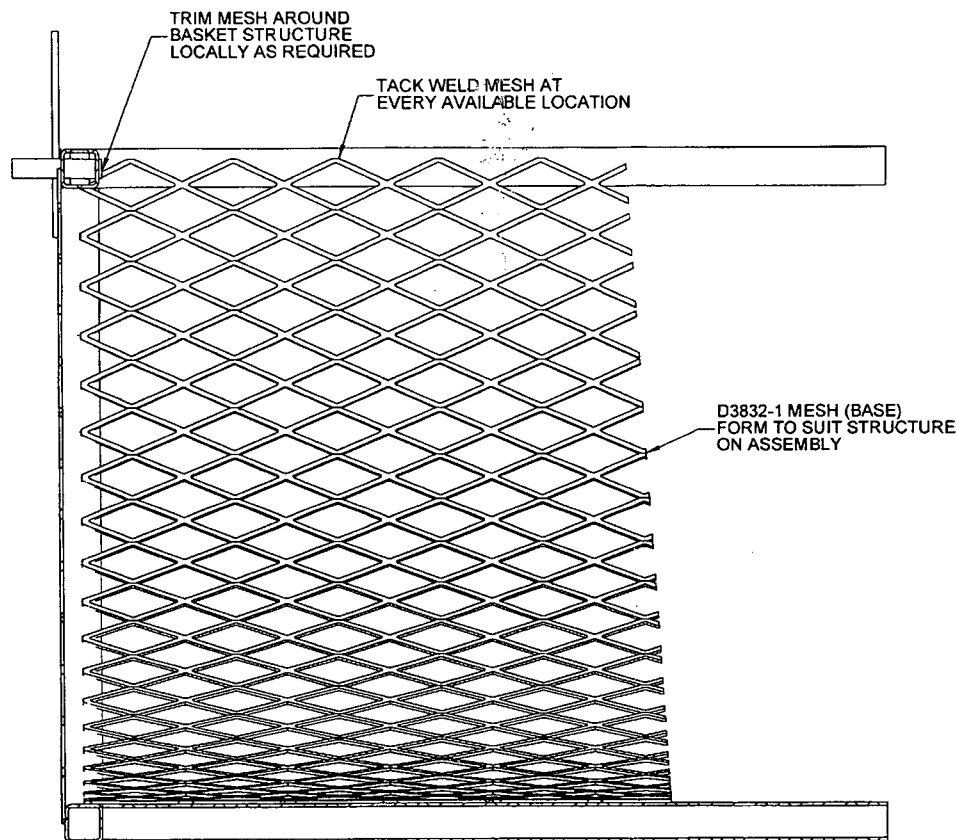


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NO. 53199

DETAIL D
SCALE 4X D2-2



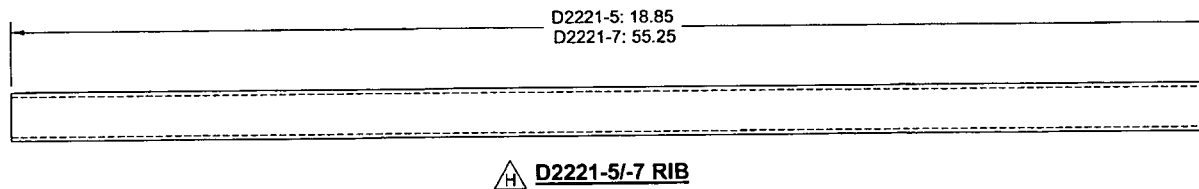
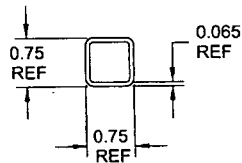
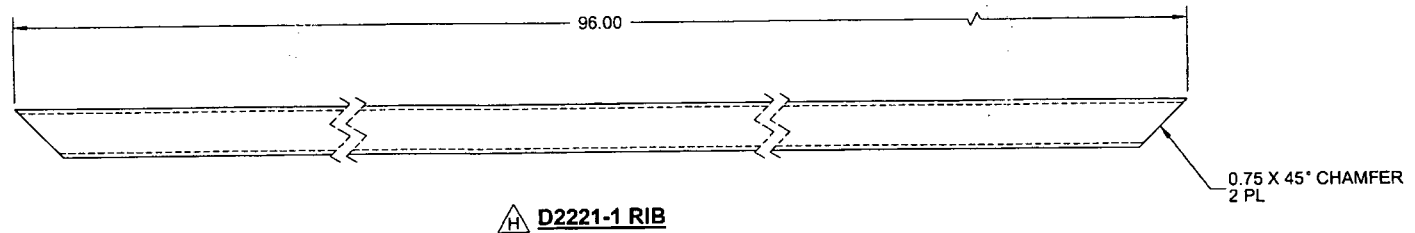
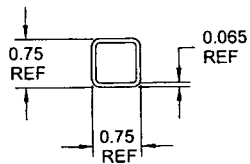
DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

RELEASED
02/11/16 MJP

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASB	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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RELEASED
08/11/18

NOTES:
MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	MY	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350) NTS	
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